

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3572-041 PAR #: _____ Fault Category: Large Smart Parts NCR: Yes No DQA: _____ Date: 10/03/16
 Resolution: Accepted Disposition: use as is QA: N/C Closed: _____ Date: 10/03/16

NCR: <u>55679</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/02	#106	Qty x4 cut too short. measure about 1/16" too short. 26.680". R.C. lack of attention when cutting	10.03.02 OS1042	ACCEPTABLE DEVIATION THIS BATCH ONLY.	10-3-2	S 10/03/02	10.03.02 OS1042	10/03/02

NOTE: Date & initial all entries

[illegible]

January 27, 2010 11:25:38 AM

[illegible]

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

2. The second step is to analyze the problem. This involves identifying the causes of the problem and determining the impact of the problem on the company.

3. The third step is to develop a solution. This involves identifying the actions that need to be taken to address the problem and determining the resources that will be required.

4. The fourth step is to implement the solution. This involves putting the solution into action and monitoring the progress of the implementation.

5. The fifth step is to evaluate the results. This involves assessing the effectiveness of the solution and determining whether the problem has been resolved.

<p>1. <i>What is the purpose of this study?</i></p> <p>2. <i>What are the research objectives?</i></p> <p>3. <i>What is the research design?</i></p> <p>4. <i>What are the variables?</i></p> <p>5. <i>What is the sample size?</i></p> <p>6. <i>What is the data collection method?</i></p> <p>7. <i>What is the data analysis method?</i></p> <p>8. <i>What are the results?</i></p> <p>9. <i>What are the conclusions?</i></p> <p>10. <i>What are the limitations?</i></p> <p>11. <i>What are the implications?</i></p> <p>12. <i>What are the future research directions?</i></p>	<p>1. <i>What is the purpose of this study?</i></p> <p>2. <i>What are the research objectives?</i></p> <p>3. <i>What is the research design?</i></p> <p>4. <i>What are the variables?</i></p> <p>5. <i>What is the sample size?</i></p> <p>6. <i>What is the data collection method?</i></p> <p>7. <i>What is the data analysis method?</i></p> <p>8. <i>What are the results?</i></p> <p>9. <i>What are the conclusions?</i></p> <p>10. <i>What are the limitations?</i></p> <p>11. <i>What are the implications?</i></p> <p>12. <i>What are the future research directions?</i></p>	<p>1. <i>What is the purpose of this study?</i></p> <p>2. <i>What are the research objectives?</i></p> <p>3. <i>What is the research design?</i></p> <p>4. <i>What are the variables?</i></p> <p>5. <i>What is the sample size?</i></p> <p>6. <i>What is the data collection method?</i></p> <p>7. <i>What is the data analysis method?</i></p> <p>8. <i>What are the results?</i></p> <p>9. <i>What are the conclusions?</i></p> <p>10. <i>What are the limitations?</i></p> <p>11. <i>What are the implications?</i></p> <p>12. <i>What are the future research directions?</i></p>
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Cust Item ID:

Customer:

[illegible][illegible]

Date:

**Insp.
Stamp**

0.00

Abstract

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572
2- grind weld flush at the end of tube only

0.00

[illegible]

Memo

0.00

Solo

410

0.00

Memo

0.00

Quality Control

70 7D 10.03.04

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NOTE: Date & initial all entries

Work Order ID 55679

January 27, 2010 11:25:38 AM

Page 3

Item ID: D3572-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Guide Assembly

Start Date: 1/27/10 Start Qty: 10.00

Cust Item ID:

Required Date: 2/05/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10/03/04

(X10) 10

Hand Finishing

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

10/03/06

(X10) 9

Powder Coating

START TIME: 10:00am
OVEN TEMPERATURE: 320-95
FINISH TIME: 10:30am

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10/03/09

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 55679

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Page 4

Item ID: D3572-041

Accept

Revision ID:

Item Name: Guide Assembly

Start Date: 1/27/10 Start Qty: 10.00

Required Date: 2/05/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: ~~FD 17~~

0.00

~~260 = 10/03/04~~

Packaging

Memo

0.00

~~X~~ 10/03/08 (12)

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/03/11

Quality Control

MC
10-3-9

W/O:		WORK ORDER CHANGES					
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Picklist Print

January 27, 2010 11:25:43 AM

Page 1

Work Order ID: 55679

Parent Item: D3572-041

Parent Item Name: Guide Assembly

Comments: IPP Rev:A New Issue 07-02-07 JLM
 IPP rev B revB dwg EC
 IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
 IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Start Date: 1/27/10

Required Date: 2/05/10

Start Qty: 10.00

Required Qty: 10.00

M6061T6T1.000W.188

Purchased No

110

f

74.5935

24.6316



Q2 10-3-2

6061T6 RD TUBE 1.00 X .188W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

74.5934542

109041

1.03

112529

20.5647542

113511

51.3987

18101

1.6

~~35~~ 22.5

D3572-3

Manufactured No

130

Each

25.0000

40.0000



Q2 10-3-4

Guide

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST244

25

55136

25

130

Each

29.0000

10.0000

25

1355725 x15

D3572-5

Manufactured No



Q2 10-3-4

Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

54119

29

10

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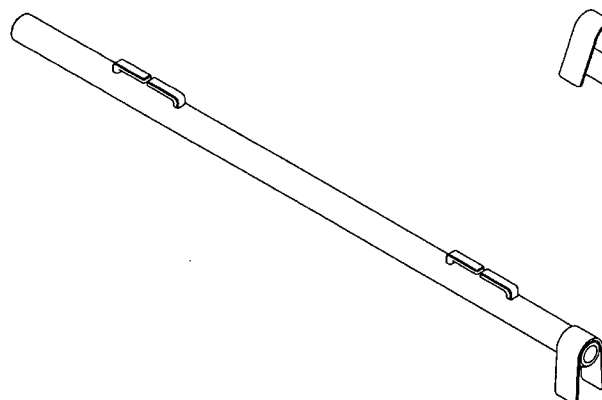
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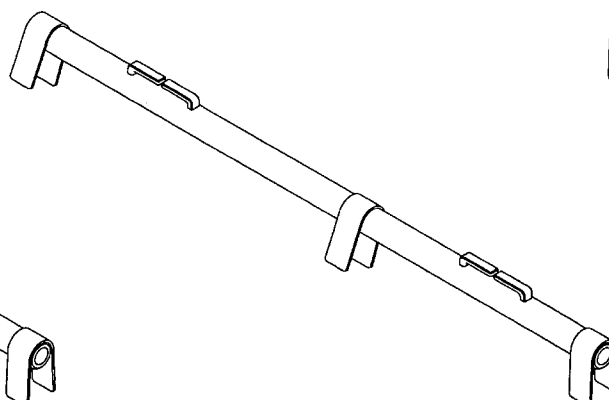
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

SHOW Y
 REVISION
 ENGINEERING
 UNCONTROLLED
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 55679
D3572-1-27

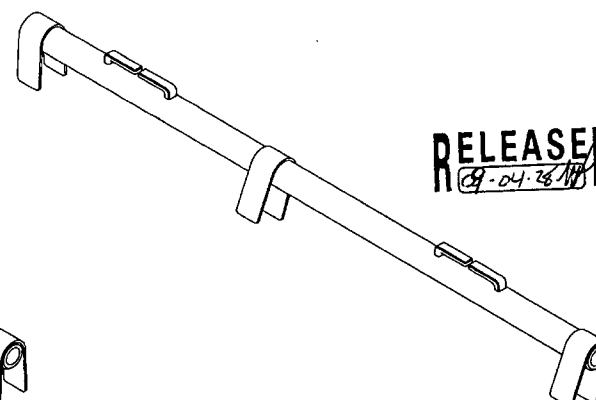
RELEASED
 09-04-28/17



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3572 REV. D SHEET 1 OF 4 TITLE GUIDE ASSEMBLY SCALE NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	09.04.17		

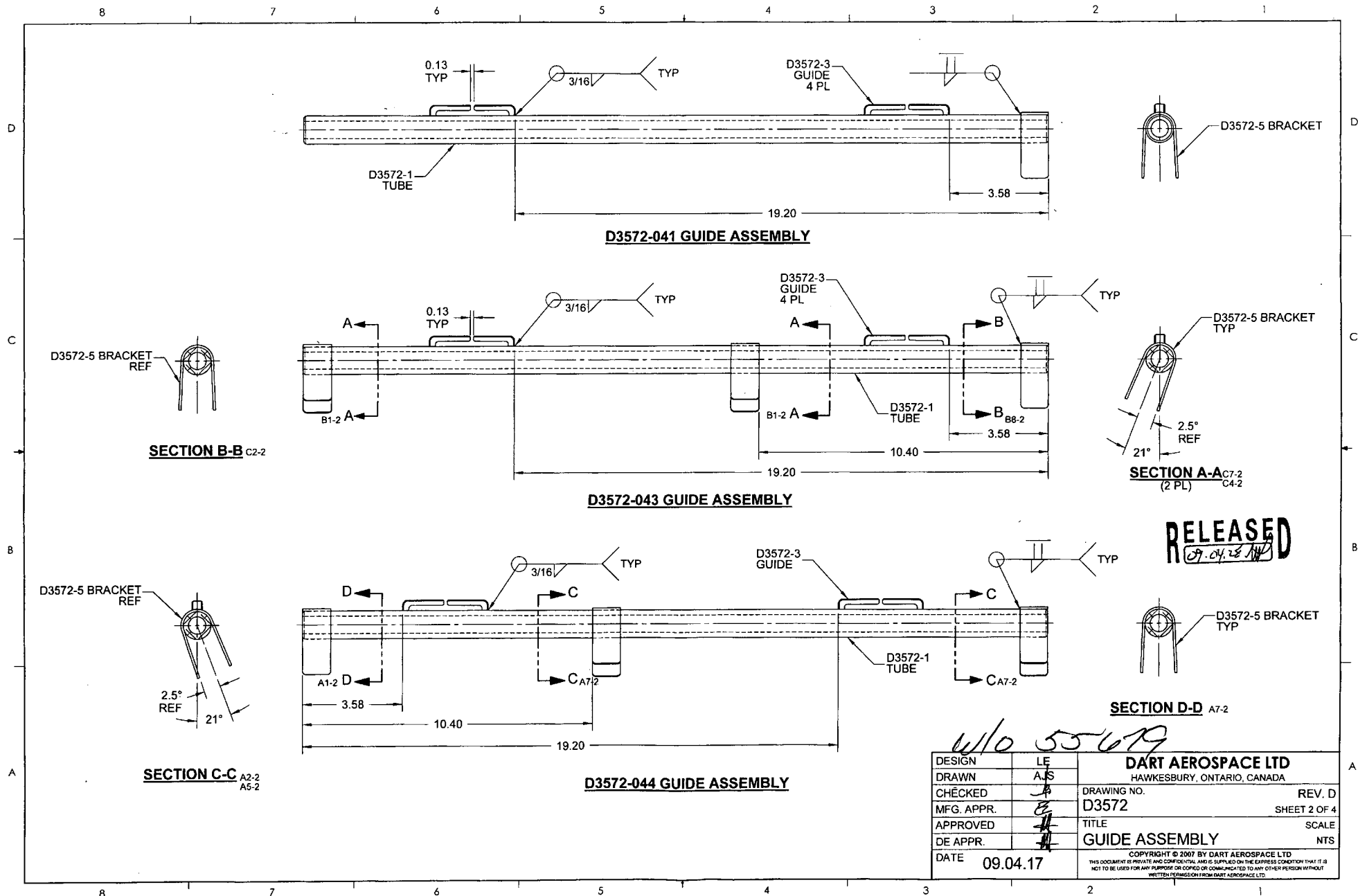
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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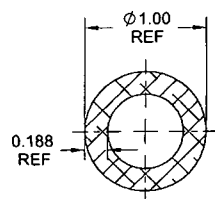
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

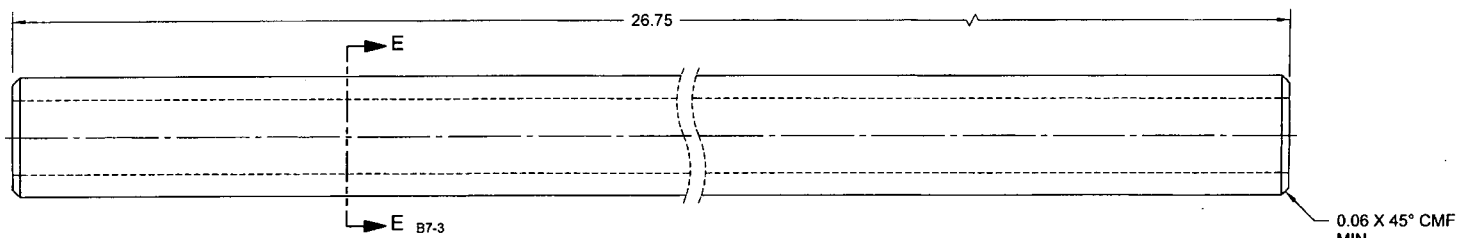
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SECTION E-E C5-3



D3572-1 TUBE

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

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09/04/17

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DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. D
MFG. APPR.	3	D3572	SHEET 3 OF 4
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DE APPR.	4	GUIDE ASSEMBLY	NTS
DATE	09.04.17	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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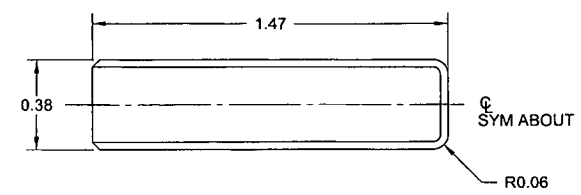
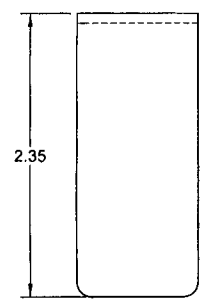
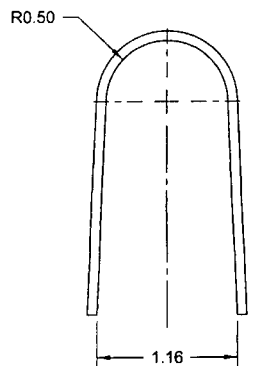
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

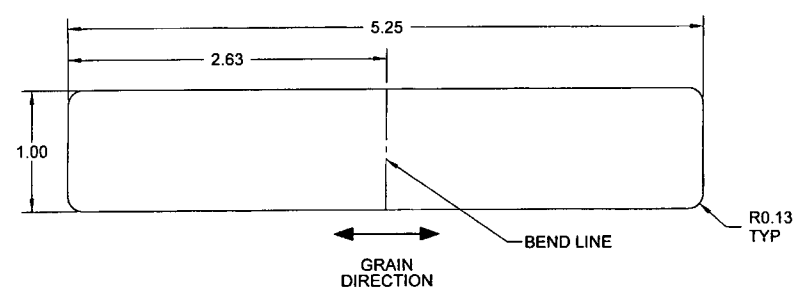
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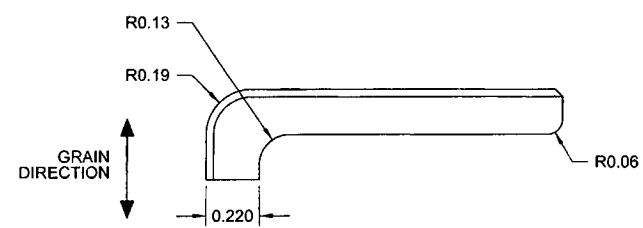
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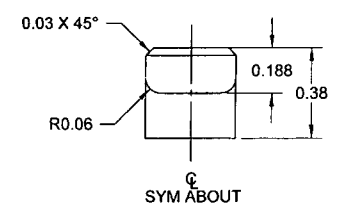
D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE



- D3572-3 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M60601T6S.080
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

- D3572-5 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.04 lbs

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9/10/18

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MFG. APPR.	J	D3572	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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